

Work Order ID 87826

Friday, July 13, 2012 3:09:20 PM

87826

Meet & ship Monday
Page 1

Item ID: D350-616-015

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Deck Plate

Stop

NS2

Start Date: 7/13/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/16/2012 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *MW*

Date: *12-07-13*

Tooling:

Date:

Run

Start

NR1

QC:

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

Draw Nbr	Revision Nbr
-----------------	---------------------

D350-616 E

100

0.00

100

DC

Document Control

Memo
Photocopy bluefile and create labels per PPP D350-616-015
CHG002

*SJL/0716
DAS
16
3-89*

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

12/7/16 SP

SP

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

*DAS
16
3-89
17/07/16*

(initials)

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset									
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

Work Order ID 87826

Friday, July 13, 2012 3:09:20 PM

87826

Page 2

Item ID: D350-616-015

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Deck Plate

Stop

NS2Start Date: 7/13/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/16/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID
130***130***

Packaging

Packaging

Operation
DescriptionSet Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MJS 12/07/16

MF
12-07-16

PP85692

NCR: Yes / No

DQA: Date: -

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Picklist Print

Friday, July 13, 2012 3:09:18 PM

Page 1

Work Order ID: 87826

Parent Item: D350-616-015

Parent Item Name: Deck Plate

Start Date: 7/13/2012

Required Date: 7/16/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed Manufacturing 05-12-05 JLM
 IPP Rev:D Add D3494-1 05-12-05 JLM
 IPP rev E added parts per NCR 08-041 08.04.30 EC verified by: DD
 IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No			110	Each	0.0000	7x10	10		M121243	③
D2344 Litter Deck Plate, 350		Manufactured	No			110	Each	16.0000		1		M118612	✓

Location	Loc Qty	Loc Code
ST224	10	
85968	10	

Location	Loc Qty	Loc Code
ST244	6	
81417	6	

Location	Loc Qty	Loc Code
ST007	40	
84753	4	
85611	36	

Location	Loc Qty	Loc Code
ST224	9	
85969	9	

Location	Loc Qty	Loc Code
ST225	6	
79474	2	
84214	4	

AN960JD10
Washer
D2344
Litter Deck Plate, 350

D2348
Wearplate

D2353
Stiffener

NCR: Yes / No

DQA: Date:

WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Bend	Grain	Ovalized	Pressure/Forced				
Centre Not Concentric to O/S				BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure				
Cracks				Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld				
Crushed/Crimped.				Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled				
Cuffs				Contamination	Maintenance	Part Moved					
Heat Treat				Countersink	Mislabeled	Positioned Wrong					
Inspection Strip in Tube				Cut Too Short	Misread	Power Loss/Surge					
Ripples in Bend				Drill Holes	Offset						
Torque Waves in Extrusion				Drawing	Out of Calibration						
Turning Sequence				Finish	Out of Sequence						
Wave/Twist in Tube				Folio	Outside Dimensions						

Picklist Print

Friday, July 13, 2012 3:09:19 PM

Page 2

Work Order ID: 87826

Parent Item: D350-616-015

Parent Item Name: Deck Plate

Start Date: 7/13/2012

Start Qty: 1.00

Required Date: 7/16/2012

Required Qty: 1.00

D2364
Deck Plate, Fwd 350 Litt

Manufactured No 110 Each 16.0000

1



Location Loc Qty Loc Code

ST224 16
81422
6
85971
10



D2365
Wearplate

Manufactured No 110 Each 34.0000

2



Location Loc Qty Loc Code

ST008 34
85781
34



D2369-1
Deck Plate Locator Brackets

Manufactured No 110 Each 15.0000

1



Location Loc Qty Loc Code

ST241A 15
84224
5
85972
10



D2369-3
Deck Plate Locator Brackets

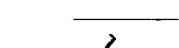
Manufactured No 110 Each 13.0000

1



Location Loc Qty Loc Code

ST241A 13
84228
3
85973
10



D3494-1
Stub Cover

Manufactured No 110 Each 8.0000

1



MS20426AD4-5
Rivet

Purchased No 110 Each 4,611.0000

25



Location Loc Qty Loc Code

ST224 8
81420
8



6874

4611
4611

25

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <hr/> <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Other	

Picklist Print

Friday, July 13, 2012 3:09:19 PM

Page 3

Work Order ID: 87826

Parent Item: D350-616-015

Parent Item Name: Deck Plate

Start Date: 7/13/2012

Required Date: 7/16/2012

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-6
Rivet

Purchased	No	110	Each	1,617.0000	\$25	25
-----------	----	-----	------	------------	------	----

Location	Loc Qty	Loc Code
ST317	1617	
110139	187	
118510	13	
119436	417	25
121708	1000	

MS20426AD5-7
Rivet

Purchased	No	110	Each	1,029.0000	\$6	6
-----------	----	-----	------	------------	-----	---

Location	Loc Qty	Loc Code
ST318	1029	
101340	1013	
7681	16	6

MS20426AD5-8
Rivet

Purchased	No	110	Each	1,129.0000	\$6	6
-----------	----	-----	------	------------	-----	---

Location	Loc Qty	Loc Code
ST318	1129	
4533	1129	b

MS20601-AD4W2
Rivet

Purchased	No	110	Each	160.0000	\$15	15
-----------	----	-----	------	----------	------	----

Location	Loc Qty	Loc Code
ST321	115	
121255	42	
121283	73	15
ST322	45	
119232	45	

MS20601-AD4W3
Rivet

Purchased	No	110	Each	1,767.0000	\$30	30
-----------	----	-----	------	------------	------	----

Location	Loc Qty	Loc Code
ST321	1767	
114538	1767	30

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending				Bend				Grain			
Centre Not Concentric to O/S				BOM/Route				Hardware			
Cracks				Broken/Damaged				Inspection Incomplete			
Crushed/Crimped.				Burrs				Instructions Incomplete/Unclear			
Cuffs				Contamination				Maintenance			
Heat Treat				Countersink				Mislabeled			
Inspection Strip in Tube				Cut Too Short				Misread			
Ripples in Bend				Drill Holes				Offset			
Torque Waves in Extrusion				Drawing				Out of Calibration			
Turning Sequence				Finish				Out of Sequence			
Wave/Twist in Tube				Folio				Outside Dimensions			
<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other											

Picklist Print

Friday, July 13, 2012 3:09:19 PM

Page 4

Work Order ID: 87826

Parent Item: D350-616-015

Parent Item Name: Deck Plate

Start Date: 7/13/2012

Start Qty: 1.00

Required Date: 7/16/2012

Required Qty: 1.00

XMS21042L3
Nut

Purchased No 110 Each 3,175.0000  6

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	1175	
117885	32	
119017	763	
119075	138	
121444	242	
ST317	2000	
122141	2000	

MS24693-C273
Screw

Purchased No 110 Each 49.0000  6

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST310	49	
120308	25	
121060	24	

MS24693-C48
Screw

Purchased No 110 Each 150.0000  22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST289	50	
121708	50	
ST302	100	
122151	100	

MS35207-264
Screw

Purchased No 110 Each 80.0000  4

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST294	80	
121415	80	

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order:		DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No. _____ NCR No. _____		Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other			

QTY - 011	Qty - 013	Qty - 015	Part Number	Description
X			D350-616-011	Full Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
1		X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
		1	D2353	STIFFENER
		1	D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
		1	D2370	LITTER ASSEMBLY
		1	D2493	PATIENT STOP
		1	D3179-041	LITTER TIE DOWN (NON-LOCKING)
		1	D3494-1	STUB COVER
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (or CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (or CR9162-4-3)
		6	MS21042L3	NUT (or MS21042-3)
		6	MS24693-C273	SCREW (or MS24693-273)
		22	MS24693-C48	SCREW (or MS24693-48)
		4	MS35207-264	SCREW
		10	NAS1149D0363J	WASHER (or AN960JD10)

RELEASED
08/11/21 MW

E	MAKE DSI 9310 STANDARD; D3179-041 REPLACES D2350		RF	08.11.07
D	ADD D3494-1 STUB COVER		MB	06.01.19
C	ADD DSI 9112/9117/9130/9236/9310		MB	06.01.10
B	ADD VIEW OF D2493 TO SHEET 9		BW	96.01.09
A	NEW ISSUE		BW	95.02.20
REV.	DESCRIPTION		BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	DS	DRAWING NO. D350-616		
MFG. APPR.	N/A	REV. E SHEET 1 OF 12		
APPROVED	DS	TITLE AS350/355 LITTER KIT INSTALLATION NTS		
DE APPR.				
DATE	08.11.07			

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	08.11.07
CERT. NO.:	SH96-10
ISSUE NO.:	2

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